



DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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**\*1 17872\***

May-05-14 11:46:40 AM

**Accept**

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 5/05/14      **Start Qty:** 12.00

**\*12\***

**Cust Item ID:**

**Required Date:** 5/05/14      **Req'd Qty:** 12.00

**\*12\***

**Customer:**

**Reference:**

Run Start \*NR1\*

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

120 QC2- Inspect parts off machine FAI/FAIB

0.00

**\*120\***

0.00

QC

## Memo

## Quality Control

**DAS**  
**37**  
**9-89**

**DAS**  
**02**  
**9-89**

02/

9-89

989 14.06.01  
14-06-03 (x12)

130 QC8- Inspect parts - second check

0.00

**\*130\***

0.00

QC

## Memo

## Quality Control

22/14/06/04

12 4

140 Chemical Conversion Coat per QSI005 4.1

0.00

**\*140\***

0.00

## HandFinish

## Memo

## Hand Finishing

12 MB 146.4

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



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# Work Order ID 117872

**\*117872\***

Page 3

May-05-14 11:46:40 AM

Item ID: D2572      Accept      **\*N900040100\***      Setup Start **\*NS1\***  
Revision ID:      Stop **\*NS2\***  
Item Name: Saddle, Fwd, In  
Start Date: 5/05/14      Start Qty: 12.00      **\*12\***      Cust Item ID:  
Required Date: 5/05/14      Req'd Qty: 12.00      **\*12\***      Customer:  
Reference:

Approvals:      Process Plan:      Date:      Tooling:      Date:      Run Start **\*NR1\***  
QC:      Date:      SPC (Y/N):      Date:      Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 <b>*150*</b> Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per OSI005 4.3-Alum <i>M128024</i>  Memo START TIME: <i>11:15</i> OVEN TEMPERATURE: <i>320</i> FINISH TIME: <i>11:45</i>	0.00  0.00				<i>12</i>	<i>0</i>	<i>14-6-10</i>	<i>DAS 34 9-89</i>
160 <b>*160*</b> QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				<i>12</i>			
170 <b>*170*</b> Packaging Packaging	Identify as per dwg & Stock Location: _____  Memo <i>ST 391</i>	0.00  0.00				<i>17/6/11</i>	<i>(12)</i>		<i>DAS 32 9-89</i>

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



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Work Order update only ☐

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### FAULT CATEGORY

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Work Order ID 117872

\*117872\*

Page 4

May-05-14 11:46:40 AM

Item ID: D2572

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Saddle, Fwd, In

Start Date: 5/05/14 Start Qty: 12.00

\*12\*

Cust Item ID:

Required Date: 5/05/14 Req'd Qty: 12.00

\*12\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
*180*									
QC	Memo	0.00							
Quality Control									

145 14-06-12

14-6-11

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



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Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
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### FAULT CATEGORY

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# Picklist Print

May-05-14 11:46:40 AM

Page 1

Work Order ID: 117872

**\*117872\***

Parent Item: D2572

**\*D2572\***

Parent Item Name: Saddle, Fwd, In

Start Date: 5/05/14

Required Date: 5/05/14

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: 102.10.02Re-format; Change to Dwg Rev. D & incorporated  
D2572KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-005		Manufactured	No			100	Each	34.0000	1	12			
<b>*D6101-005*</b>									<b>**</b>			<b>DAS</b>	
Saddle Billet												<b>25</b>	<b>11-5-30</b>
												<b>8-89</b>	

Location

Loc Qty

Loc Code

MAT041

34

106698

20

115286

14

\* 12

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



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Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Small

<b>DART AEROSPACE LTD—</b>	<b>Work Order:</b> 117872
<b>Description:</b> Saddle, Fwd Inboard	<b>Part Number:</b> D2572
<b>Inspection Dwg:</b> D2572 Rev. F	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.000	8.001	7.999		
F	0.490	0.510		.496	.495	.496	.497		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.376	.376	.376	.376		
I	0.490	0.510		.499	.494	.495	.5005		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.565	.564	.565	.5685		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.135	.135	.135	.135		
Q	0.115	0.135		.125	.125	.125	.125		
R	0.240	0.260		.249	.249	.249	.249		
S	0.115	0.135		.125	.125	.125	.125		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.961	2.9605		
V	0.230	0.250		.236	.235	.236	.238		
W	0.115	0.135		.125	.125	.124	.124		
X	0.307	0.312		.318	.318	.318	.318		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.370	.370	.370	.370		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.624	.624	.626		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.247	.249	.250	.250		
AE	1.375	1.395		1.388	1.387	1.388	1.388		
AF	0.115	0.135		.125	.125	.125	.125		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.250	.250	.250	.250		
AI	2.000	2.020		2.002	2.000	2.001	2.001		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

DAS

Measured by:	37
Date:	9-89/14.06.01

Audited by:	cmf
Date:	14/06/04

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

Small

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	117872
<b>Description:</b> Saddle, Fwd Inboard		<b>Part Number:</b>	D2572
<b>Inspection Dwg:</b> D2572 Rev. F		<b>Page 1 of 1</b>	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	85	86	87	88		
A	0.438	0.443		.440	.440	.440	0.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.002	8.001	8.001		
F	0.490	0.510		.498	.499	0.499	0.497		
G	0.257	0.262		.258	.258	.258	0.258		
H	0.375	0.380		.376	.376	.376	0.376		
I	0.490	0.510		.499	.478	0.500	0.499		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.569	0.566	0.565		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.135	.125	.125	0.125		
Q	0.115	0.135		.125	.125	.125	0.124		
R	0.240	0.260		.249	.249	.249	0.249		
S	0.115	0.135		.125	.125	.130	0.131		
T	0.178	0.198		.188	.188	.188	0.188		
U	2.940	2.980		2.962	2.961	2.960	2.960		
V	0.230	0.250		.238	.238	0.237	0.237		
W	0.115	0.135		.125	.124	0.135	0.135		
X	0.307	0.312		.312	.312	.312	0.312		
Y	0.760	0.765		.760	.760	.760	0.760		
Z	0.352	0.372		.370	.370	.370	0.370		
AA	0.470	0.530		.500	.500	.500	0.500		
AB	0.615	0.635		.625	.625	.625	0.625		
AC	0.053	0.073		.063	.063	.063	0.060		
AD	0.240	0.260		.249	.250	0.249	0.249		
AE	1.375	1.395		1.388	1.388	1.388	1.387		
AF	0.115	0.135		.125	.125	.125	0.125		
AG	0.240	0.280		.260	.260	.260	0.260		
AH	0.240	0.260		.250	.250	.250	0.247		
AI	2.000	2.020		2.002	2.001	2.002	2.003		
AJ	0.023	0.043		.033	.033	.033	0.033		
Accept/Reject									

DAS

Measured by:	37
Date:	9-89 14.06.02

Audited by:	Amf
Date:	14/06/04

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 117872
<b>Description:</b> Saddle, Fwd Inboard		<b>Part Number:</b> D2572
<b>Inspection Dwg:</b> D2572 Rev. F		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				# 9	# 10	# 11	# 12		
A	0.438	0.443		0.440	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		0.496	0.496	0.497	0.495		
G	0.257	0.262		0.260	0.260	0.260	0.260		
H	0.375	0.380		0.376	0.376	0.376	0.376		
I	0.490	0.510		0.498	0.498	0.498	0.499		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.564	0.563	0.565	0.564		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		0.125	0.125	0.125	0.125		
Q	0.115	0.135		0.124	0.124	0.124	0.124		
R	0.240	0.260		0.251	0.250	0.250	0.250		
S	0.115	0.135		0.133	0.129	0.133	0.133		
T	0.178	0.198		0.188	0.186	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.237	0.239	0.237	0.238		
W	0.115	0.135		0.133	0.134	0.134	0.134		
X	0.307	0.312		0.311	0.310	0.312	0.311		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.370	0.370	0.370	0.370		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.625	0.625	0.625	0.625		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.250	0.248	0.248	0.248		
AE	1.375	1.395		1.387	1.386	1.386	1.389		
AF	0.115	0.135		0.125	0.125	0.125	0.125		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.245	0.247	0.246	0.246		
AI	2.000	2.020		2.003	2.003	2.003	2.006		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		

Accept/Reject DAS

Measured by:	02 9-89
Date:	14-06-03

Audited by:	
Date:	14/06/04

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

